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(54) **PRODUCTION OF HARD ROLL**

Integrated by this process to obtain a resin-coated roll.

(57) Abstract

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PURPOSE: To produce a high-quality calender roll in high efficiency, by winding a fibrous material impregnated with a thermosetting resin around the outer circumference of a roll core made of a metal, covering a cylinder made of a resin on the outer surface of the wound fibrous material, pouring a thermosetting adhesive in the gap between the cylinder and the core and hardening the adhesive.

CONSTITUTION: A resin-coated hard roll used as an elastic roll for calender roll is produced by the following process. A thermosetting synthetic resin is poured into a cylindrical mold and cured to obtain a cylinder 3 for outer-layer. Separately, a cloth impregnated with a thermosetting resin is wound around the outer circumference of a metallic roll core 1 form a fiber-reinforced substrate layer 2. The cylinder 3 for outer layer is covered on the substrate layer 2, an adhesive 4 having low viscosity is poured in the gap between the substrate layer and the cylinder and the assembly is heat-treated to cure the thermosetting resin. The individual components are bonded and

